Friday, 25/07/2008 4:20:54 PM

User:

Julie Lecoca

### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number** 

: 40764 : 13511

Prsht Rev.

P.O. Number

: 25/07/2008 This Issue

: NC

: // First Issue

**Previous Run** 

Written By

Checked & Approved By

Type

: Est Rev:A 08-07-24 new issue ec verified by:dd

: SMALL /MED FAB

**Additional Product** 

Job Number:



Seq. #:

1.0

**Machine Or Operation:** 

M304S16GA

Comment: Qty.: 0.2216 sf(s)/Unit Total: 304 SS Sheet 0.063" thick

batch: 168 724

0.4431 sf(s)

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D2196

Dwg Rev:\_ Prog Rev: B8-8-91

2-Deburr if necessary

HB 8-8-21

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE







Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Bend as per dwg D2196

Part Number : D21962

**Drawing Number** 

**Drawing Name** 

: D2196 REV C : N/A

: BRACKET

Project Number : C **Drawing Revision** 

Material

Description:

304/316 Sheet .063

FLOW WATER JET

SECOND CHECK

: 20/08/2008 **Due Date** 

Qty:

2 Um:

Each















Dart Aerospace L	_ta
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Dart Ae	rospace	Ltd						i	
W/O:			W	ORK ORDER CHANGE	S			ĺ	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng /ı Prod Mgr	Approval QC Inspector
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	<del></del>							<del> </del>	J.,
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DC	(A:	_ Date: _	
		<u>``</u>		•	QA:	N/C Close	ed:	_ Date: _	
NCR:		\	NORK ORD	ER NON-CONFORMAI	NCE (NC	R)			
		Description of NC		Corrective Action Section	n B	Verifi	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
								!	

		WORK ORDER NON-CONFORMANCE (NCR)								
STEP	Description of NC		Corrective Action Section B	Verification						
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Friday, 25/07/2008 4:20:54 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 40764 Part Number: D21962 Job Number: Seq. #: **Machine Or Operation:** Description: QC5 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Identify wiith Dart part # using a fine point permanent marker and Stock Location: 8.0 QC21 FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08,08,26

# **Dart Aerospace Ltd**

	•	я.						
W/O:			WC	ORK ORDER CHANG	GES			
DATE	STEP	PRC	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							1	
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date:	······
					QA: N	/C Closed:	Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR	)	i	
D.4.T.E.	STEP Description of NC Section A	Description of NC Corrective Action Sec			tion B Verification		Approval	Approval
DATE		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
· 								
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· 1							i	

NOTE: Date & initial all entries

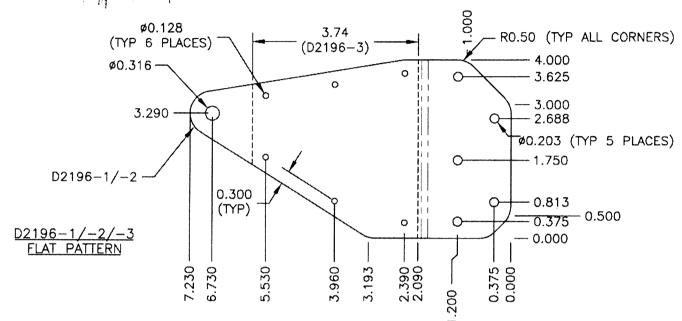




DESIGN	#	DRAWN BY	1	RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED 🚜	APPROVED	DRAWING NO.		REV. C
	#	10	D2196	SHEET	1 OF 1
DATE			TITLE		SCALE
03.0	5.28		BRACKET		1:2
В		93.09.23	REDESIGN		

# 030)09

C 03.05.28 REDRAW; D2196-3 NOW 0.5" THICK



D2196-1/-2

1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)

#### D2196 - 3

2) MATERIAL: 5052H32 (QQ-A-250/8) 0.500" THICK 4x0.125 THICK

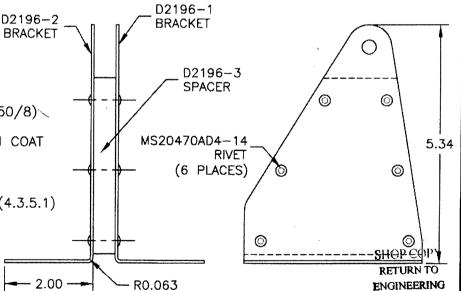
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

### D2196 BRACKET (ASSEMBLY):

4) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

### **GENERAL NOTES:**

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2196 BRACKET (ASSEMBLY)

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SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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DART AEROSPACE LTD	₩ork Order:	40764
		B 5 1/2   5
Description: RRACLET	Part Number:	D2146-4
Inspection Dwg: 1) 2/9(,-) Rev: (		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861, 🔯	1005-001	:131	*			
6 .303	+ 605 - 001	1204	*			
0 316	1.006-001	317	*			
375	4- 010	375	e			
. 813	1/2 010	,814	*			
1.750	-010	1.752	×			
3.688	4 .00	832,6	80			
3.675	4 .010		Ø.			
4.000	1/ .010	4.006	¥			
,375	1 .010	1375	*			
1.700	4010	1.203	*			
2.390	7010	2.393	¥			
3960	400	3,962	*			
5.230	610.	5,530	Q		· · · · · · · · · · · · · · · · · · ·	
6.730	4010	6.730	× ·			
7.230	4010	7,229	*			
,063	4- 2010	.060	×			
			,			
			·			

Measured by:	B	Audited by:	5	Prototype Approval:	1	<i>†</i>
Date:	8-8-21	Date:	08/08/21	Date:		6

Γ	Rev	Date	Change	Revised by	Approved
Γ	Α		New Issue	KJ/JLM	

